

Ship 20/07

Dart Aerospace Ltd.

29

Date: Wednesday, 7/11/2007 2:32:51 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARMOR SHIELD  
Job Number : 33502  
Estimate Number : 12378  
P.O. Number : N/A Part Number : D206667203A  
This Issue : 7/11/2007 S.O. No. : N/A Drawing Number : DSI9326  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : LANDING GEAR Drawing Revision : A  
Previous Run : 33313 Material : N/A  
Written By : Due Date : 7/20/2007 Qty: 1 Um: Each  
Checked & Approved By : 07.07.11  
Comment : Est Rev: A New Issue 06-04-19 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL

Comment: Photocopy bluefile & type labels per PPPD206-667-203A CHG001  
Add DSI 9326 to existing paper work. Per attached.

2.0 D206667203 Crosstube Installation

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Fwd Crosstube  
Batch: 32668 ET 07-07-14

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1  
1-Remove tube from packaging2-Apply Armor shield as per DSI 9326  
A/R Armor Shield Batch: 104994 ET 0707-14

4.0 QC14 INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

5.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1  
Identify and pack for shipping as per PPP D206-667-203A  
Location: \_\_\_\_\_  
PPP Rev: \_\_\_\_\_  
Rev 07/11/07 SP 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 01/07/03

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 2:32:51 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARMOR SHIELD

Job Number: 33502

Part Number: D206667203A

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.07.17

Job Completion



u 07.07.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>J.J.</i>	APPROVED <i>H</i>	DRAWING NO. DSI 9326	REV. A SHEET 1 OF 1
DATE 06.02.14		TITLE ARMOR SHIELD	SCALE NTS
A	06.02.14	NEW ISSUE	

## DART SERVICE INSTRUCTION

To further protect Dart crosstubes from mechanical damage in service, they may be treated with "Armor Shield" surface treatment.

INSTALLATION	CANADIAN STC	FAA STC
D205-596-101/-103/-105/-107	SH03-6	SR01742NY
D212-664-101/-201	SH01-9	SR01298NY
D412-664-203		
D206-667-101/-103/-201/-203	SH01-5	SR01304NY
D407-667-105/-205		
D058-676-101/-201	N/A	SR01018SE

To designate crosstubes with 'Armor Shield' add 'A' to the Part Number. For example, D206-667-101A is a D206-667-101 crosstube coated with Armor Shield. It is acceptable to apply the Armor Shield in regions shown in Figure.1 only. It is **NOT** acceptable to apply Armor Shield in the cuff and support/clamp regions.

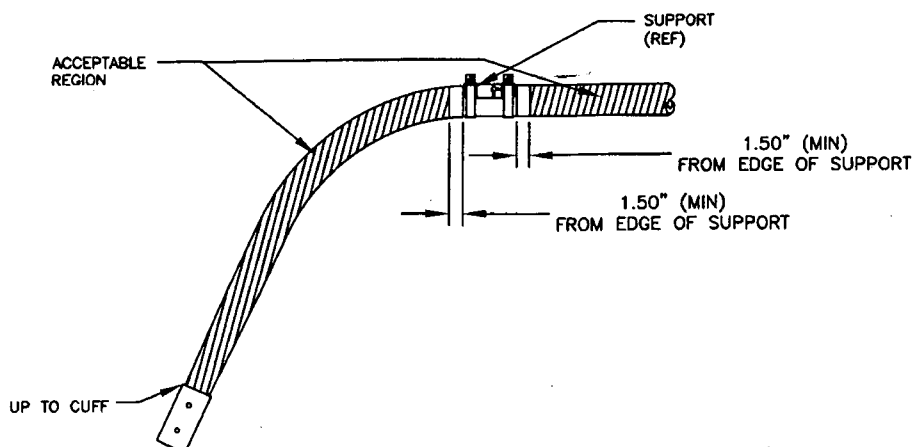
### 1.0 To apply Armor Shield

- 1) Ensure the crosstube is appropriately finished in accordance with the relevant manufacturing drawing or Instruction for Continued Airworthiness (ICA).
- 2) Mask areas around supports and cuffs per Figure 1. Abrade paint finish in areas requiring protection using 320 grit sandpaper.
- 3) Clean/degrease surface of crosstube using Methyl Ethyl Ketone (MEK), 4105S Wash'n Wipe Degreaser, or equivalent and wipe the surface to clean the entire area
- 4) Apply 3 coats of Proform PF 746 or PF 746-1 to surface  
(apply additional coats when surface is dry, but not fully cured)
- 5) Allow 5 hours for coating to dry.
- 6) Apply 2 coats of Imron 500s Polyurethane Enamel clear + Dupont Imron Polyurethane Enamel Activator 192S (mix 3:1). Mix 15 minutes prior to application and allow 15 minutes before applying additional coats.

### 2.0 Armor Shield removal/re-application

To remove the Armor Shield coating or if damage to the coating and/or crosstube is observed during inspection.

- 1) Remove Armor Shield from the affected area using 80 grit sandpaper. To remove Armor Shield from larger areas, bead blasting has been determined to be the most effective technique.
- 2) Repair mechanical damage (within limits) to the crosstube and touch up finish in accordance with the relevant ICA.
- 3) Apply Armor Shield in accordance with Section 1.0 of these instructions.



**FIGURE 1 - ACCEPTABLE REGIONS TO BE COATED WITH ARMOR SHIELD**

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 33502

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 06.02.14  
CERT. NO.: SH03-6/SH01-9/SH01-5  
ISSUE NO.: 3/3/3

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Date: Friday, 5/25/2007 12:47:28 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L AFT X-TUBE  
Job Number : 32668  
Estimate Number : 10973  
P.O. Number :  
This Issue : 5/25/2007 S.O. No. :  
Prsht Rev. : NC Part Number : D206667203  
First Issue : // Type : LANDING GEAR Drawing Number : D206-667-243 REV B  
Previous Run : 32458 Material :  
Written By : Due Date : 6/20/2007 Qty: 1 Um: Each  
Checked & Approved By : 07.05.28  
Comment : Est Rev: F 05.09.01 Add holes for compatibility with Bell  
Skidtubes KJ/JLM

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG002

07.06.02

2.0

D6004115

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number

Description Batch

1 D6004-115

Crosstube

Check OD = 2.500"; ID = 1.800"

MORI SEIKI CNC LATHE LARGE

3.0

MORI SEIKI



Comment: MORI SEIKI

with sand &amp; install plugs DT8534 on both ends as per Folio FA089

Turn first side as per Folio FA089

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

QC1

INSPECT ALL DIM TO DIM SHEET

Comment: INSPECT ALL DIM TO DIM SHEET



REFERENCE ONLY